

Work Order ID 76460

76460

Page 1

November-15-11 8:04:44 AM

Item ID: D4106-7 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Template
 Start Date: 15/11/2011 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 29/11/2011 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/11/15 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4106	A								

100 0.00

100

Waterjet

FLOW CNC Waterjet

0.00 LEVAN

Memo

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

0.00

B12-1-18

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

B12/01/18 (8)

B12-1-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	S 12/01/18			(48)			
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: <u>127</u> Memo	0.00 0.00	12/1/19					82	
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00	12/1/20						

MLJ 12/01/20
(8)

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NOTE: Date & initial all entries

Picklist Print

November-15-11 8:04:48 AM

Page 1

Work Order ID: 76460

76460

Parent Item: D4106-7

D4106-7

Parent Item Name: Template

Start Date: 15/11/2011

Required Date: 29/11/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.09.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.060-9034-08		Purchased	No			100	sf	34.5400	0.2109	0.888	2.		
MI FXS 060-9034-08										**	312-1-18		
.060" 9034 Lexan Sheet													

Location

Loc Qty

Loc Code

MAT020

7.54

115569

7.54

therm

27

117339

27

117339

8

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NOTE: Date & initial all entries

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

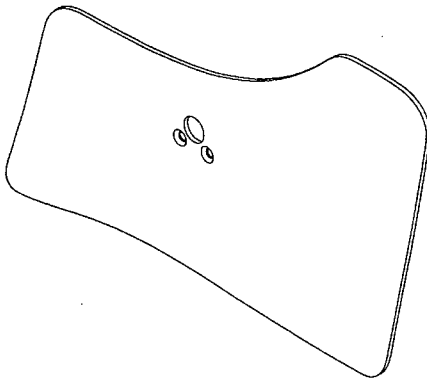
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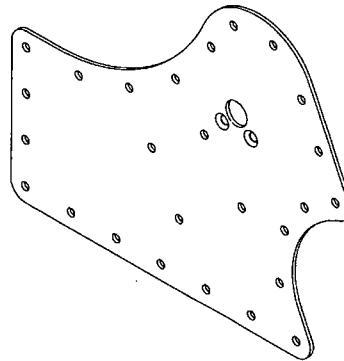
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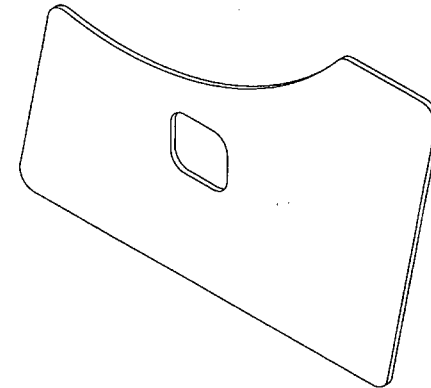
8 7 6 5 4 3 2 1



D4106-1 SILL DOUBLER, LH

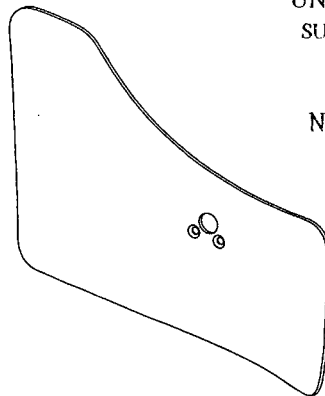


D4106-3 CREW DOOR DOUBLER, LH

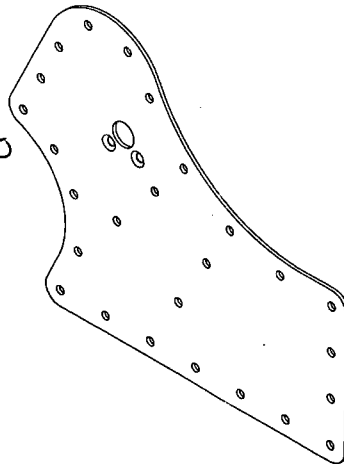


D4106-5 SPACER, SILL DOUBLER

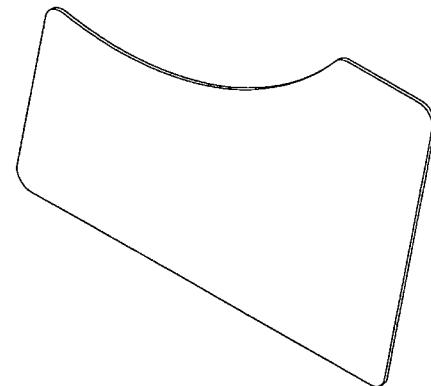
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 76460 M.L.J
11/11/15



D4106-2 SILL DOUBLER, RH







D4106-4 CREW DOOR DOUBLER, RH



D4106-7 TEMPLATE

RELEASED
2010-09-23
JPH

A		NEW ISSUE		JPH		10.07.15			
REV.		DESCRIPTION				BY		DATE	
DESIGN		JPH		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA					
DRAWN		JPH							
CHECKED				DRAWING NO.				REV. A	
MFG. APPR.				D4106				SHEET 1 OF 5	
APPROVED				TITLE				SCALE	
DE APPR.				DOUBLERS				NTS	
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

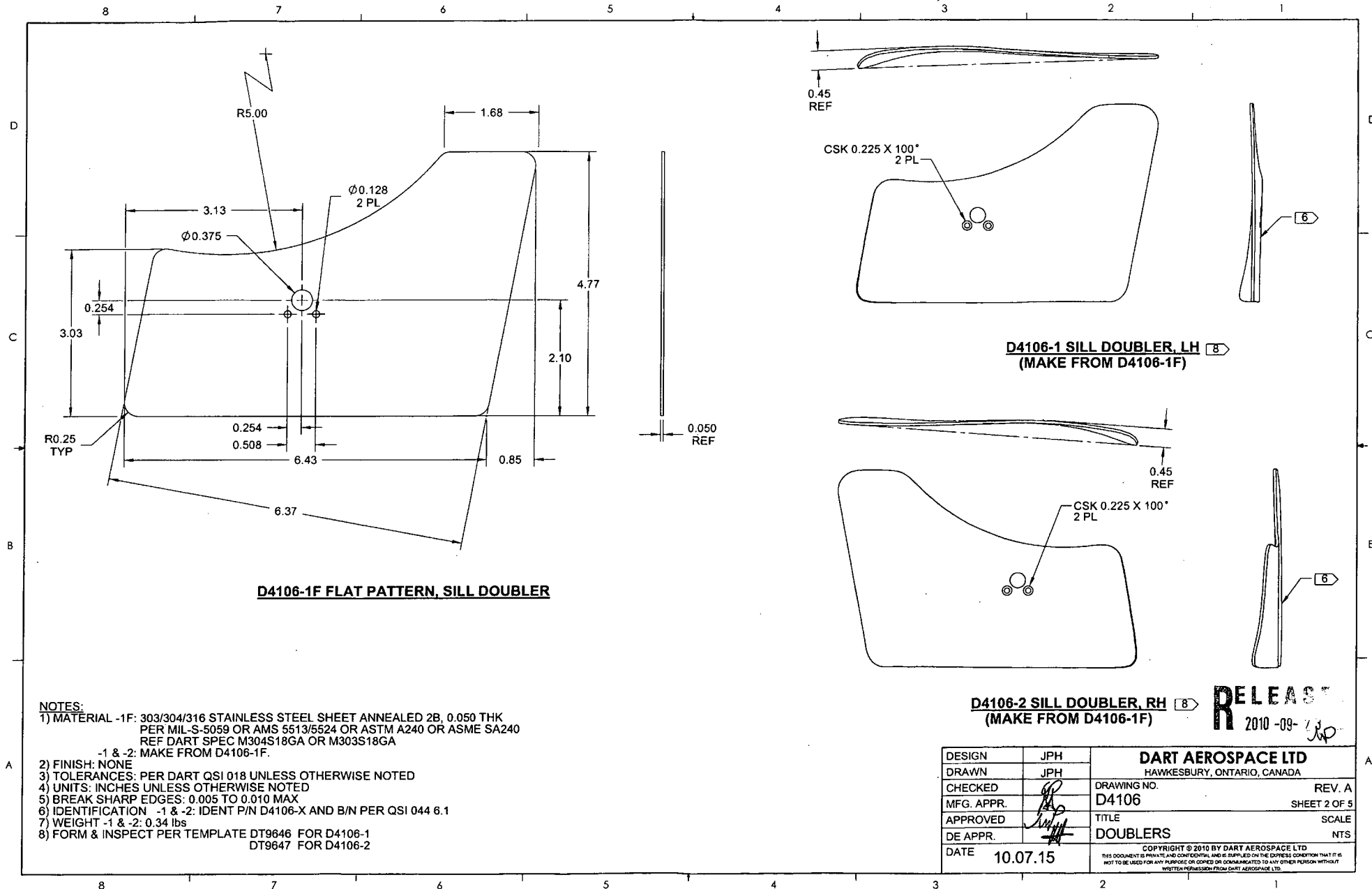
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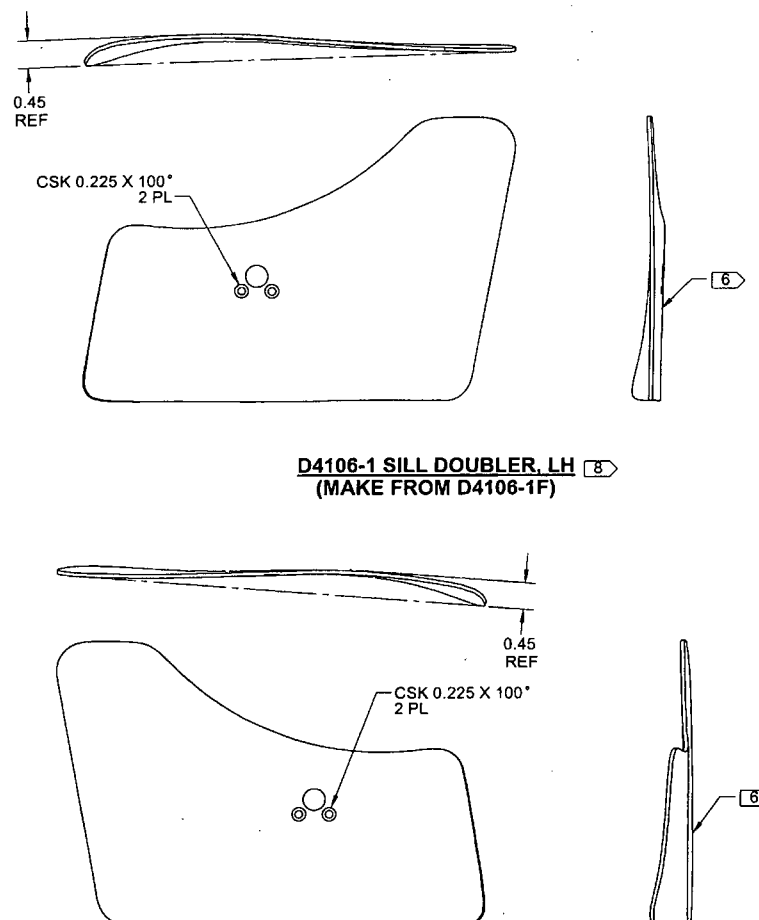
76460



D4106-1F FLAT PATTERN, SILL DOUBLER

NOTES:

- 1) MATERIAL -1F: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.050 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S18GA OR M303S18GA
-1 & -2: MAKE FROM D4106-1F.
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION -1 & -2: IDENT P/N D4106-X AND B/N PER QSI 044 6.1
- 7) WEIGHT -1 & -2: 0.34 lbs
- 8) FORM & INSPECT PER TEMPLATE DT9646 FOR D4106-1
DT9647 FOR D4106-2



D4106-1 SILL DOUBLER, LH (MAKE FROM D4106-1F)

D4106-2 SILL DOUBLER, RH (MAKE FROM D4106-1F)

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO. D4106	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 5	
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DE APPR.	<i>[Signature]</i>	DOUBLERS	NTS
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RELEASE
2010-09-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

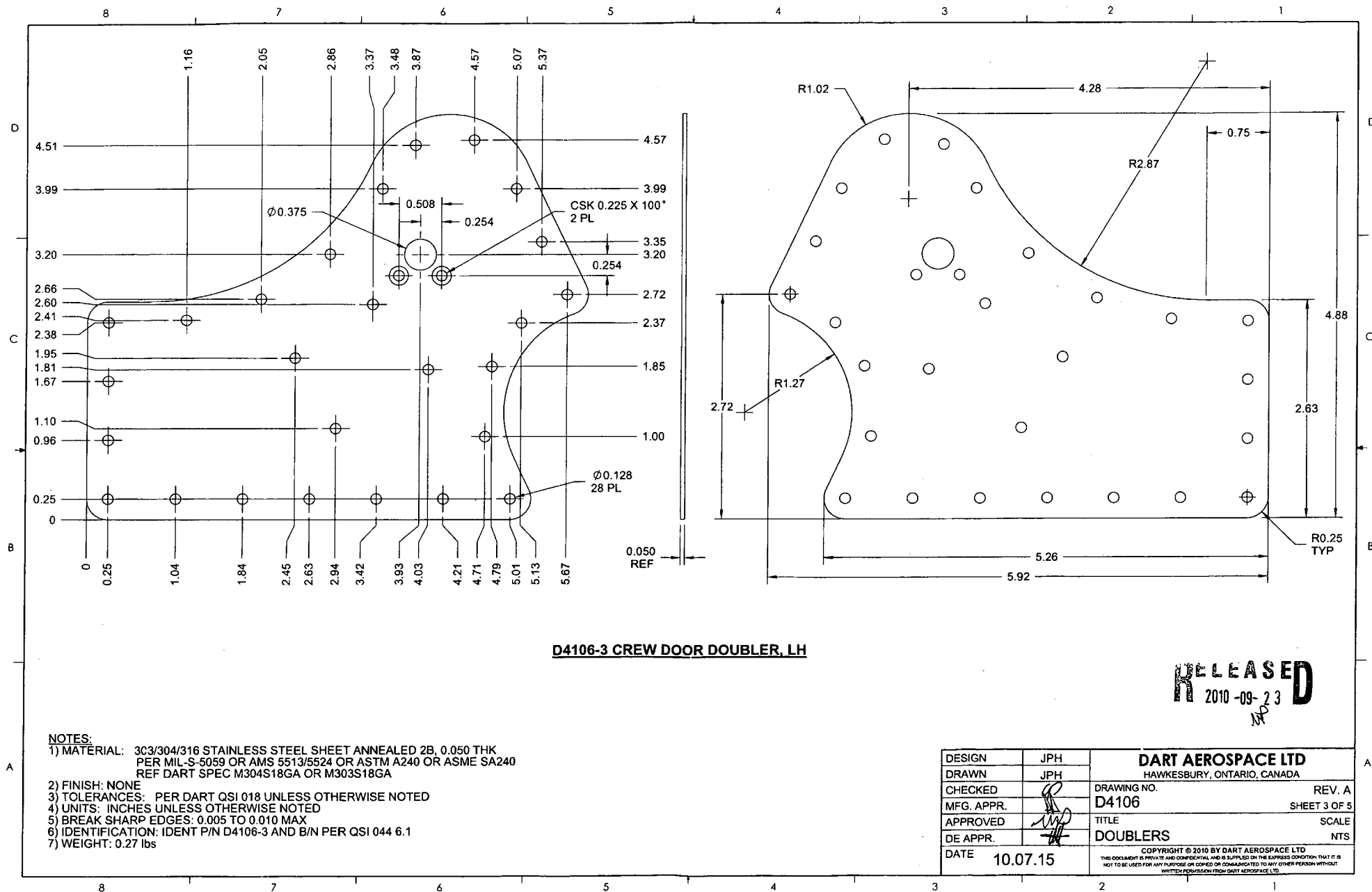
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

76466



RELEASED
 2010-09-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

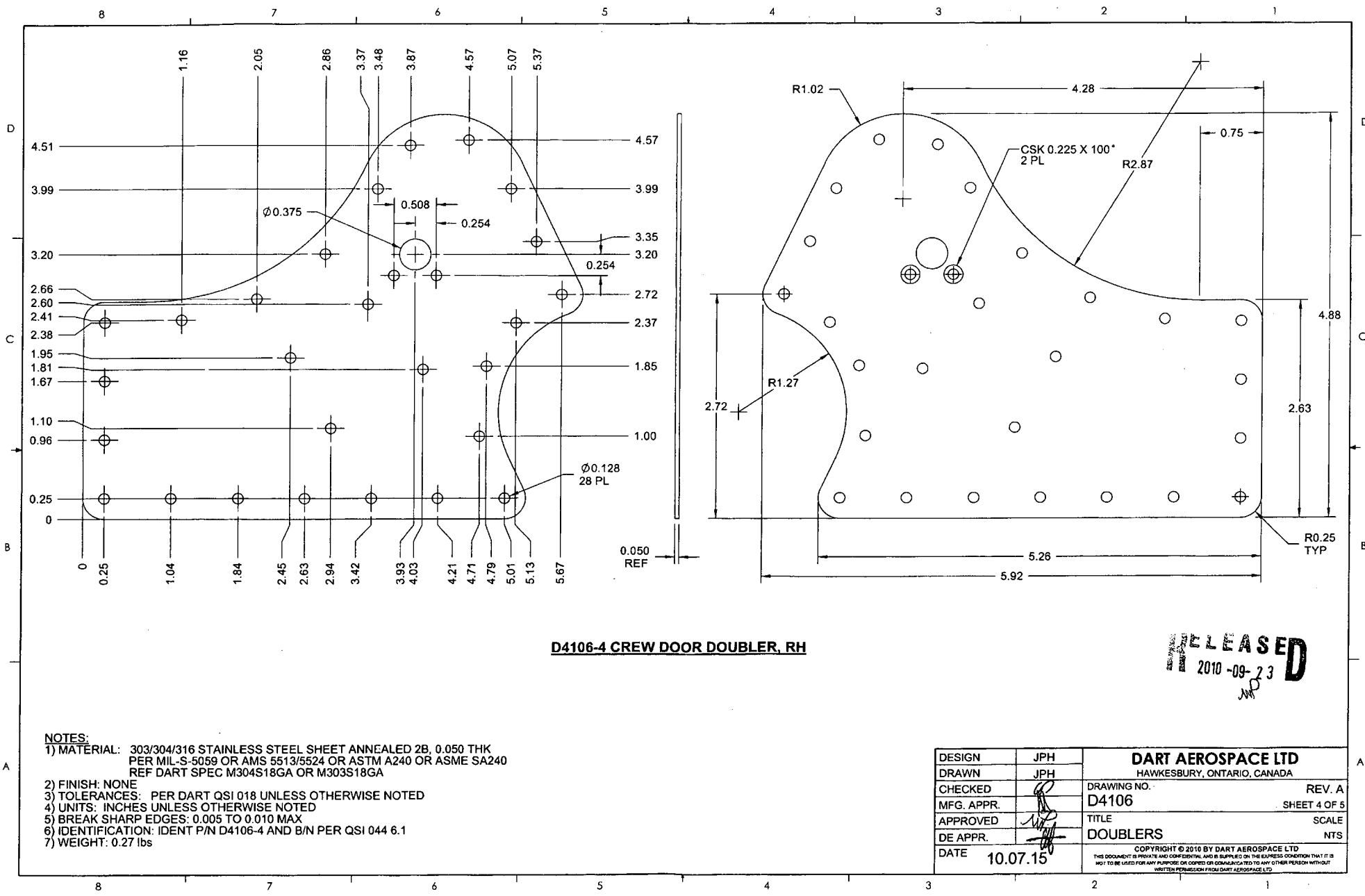
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

76466



D4106-4 CREW DOOR DOUBLER, RH

RELEASED
2010-09-23

- NOTES:
- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.050 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S18GA OR M303S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENT P/N D4106-4 AND B/N PER QSI 044 6.1
 - 7) WEIGHT: 0.27 lbs

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4106	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 4 OF 5	
APPROVED	<i>[Signature]</i>	TITLE DOUBLERS	SCALE NTS
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DATE	10.07.15		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

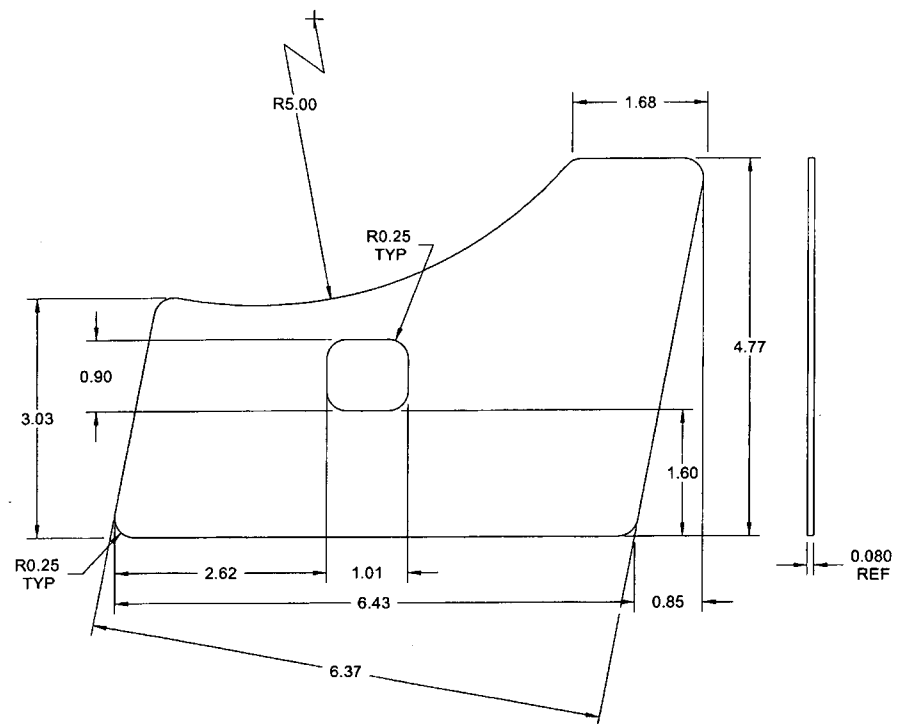
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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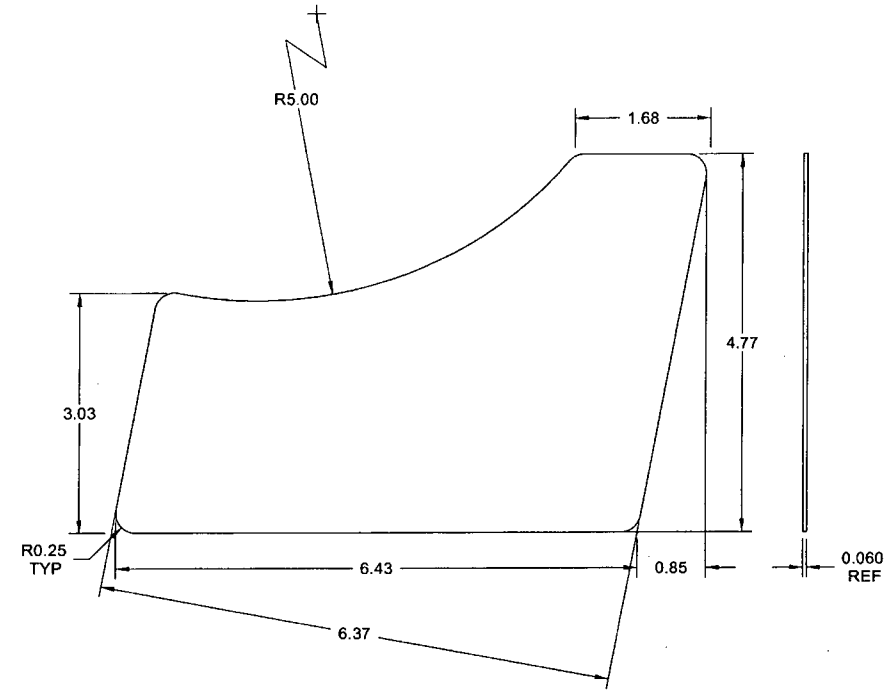
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NOTE: Date & initial all entries

76460



D4106-5 SPACER, SILL DOUBLER



D4106-7 TEMPLATE

- NOTES:**
- 1) MATERIAL -5: KYDEX 6185 SHEET, 0.080 THK
REF DART MKYD6185S.080-P3-52068 OR MKYD6185S.080-P3-62015
 - 7: LEXAN 9034 SHEET, 0.060 THK
REF DART MLEXS.060-9034-08
OR POLYCAST II CLEAR ACRYLIC, .060 THICK.
REF DART M-ACRYLIC-S.060
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENT P/N D4106-X PER QSI 044 6.1
 - 7) WEIGHT -5: 0.08 lbs
-7: N/A

RELEASED
2010-09-23

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4106	SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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